

Work Order ID 63284

Wednesday, October 27, 2010 10:16:45 AM

Page 1

Item ID: D212-725-1-197F

Accept

Revision ID:

Item Name: Cowl Bracket

Start Date: 10/27/2010 Start Qty: 4.00

Required Date: 11/30/2010 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date: 10-10-27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D212-725-1

D

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

B 10-10-27

4

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63284

Wednesday, October 27, 2010 10:16:45 AM

Page 2

Item ID: D212-725-1-197F

Accept

Setup Start

Revision ID:

Stop

Item Name: Cowl Bracket

Start Date: 10/27/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S 10/10/28

(24)

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

SB 10/10/29

(4)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/10/29

(24)

W/O:		WORK ORDER CHANGES					
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Work Order ID 63284

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Page 3

Item ID: D212-725-1-197F

Accept

Revision ID:

Item Name: Cowl Bracket




Start Date: 10/27/2010 Start Qty: 4.00

Required Date: 11/30/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start _____
Stop _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>380</u> Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63284

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Wednesday, October 27, 2010 10:16:45 AM

Item ID: D212-725-1-197F

Accept



Setup Start



Revision ID:

Stop



Item Name: Cowl Bracket

Start Date: 10/27/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-10-29

10-10-29
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, October 27, 2010 10:16:49 AM

Work Order ID: 63284



Parent Item: D212-725-1-197F



Parent Item Name: Cowl Bracket


Start Date: 10/27/2010

Required Date: 11/30/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 10.07.21 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	89.0000	0.048	0.202105			
													
2024-T3 .063 sheet													



10-10-27

Location

Loc Qty

Loc Code

MAT22

89

113866

8.5

114351

80.5

113866

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

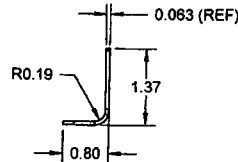
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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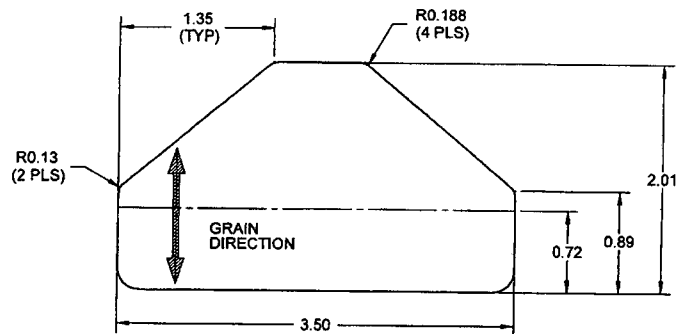
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. *63284*
BS10-10-27



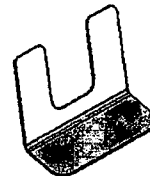
D212-725-1-197 COWL CLIP
(MAKE FROM D212-725-1-197F)



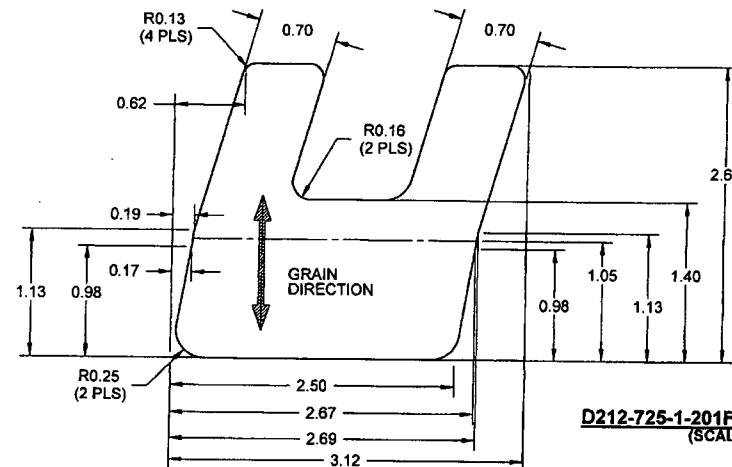
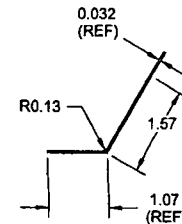
D212-725-1-197F FLAT PATTERN
SCALE 1:1

D212-725-1-197 NOTES:

- 1) MATERIAL: 2024-T3 SHEET 0.063 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A



D212-725-1-201 DOUBLER
D212-725-1-202 OPPOSITE
(MAKE FROM D212-725-1-201F)



D212-725-1-201F FLAT PATTERN
(SCALE 1:1)

D212-725-1-201-202 NOTES:

- 1) MATERIAL: 2024-T3 SHEET 0.032 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.032)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A

RELEASED
2009-10-28

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. D
MFG. APPR.	N/A	D212-725-1	SHEET 66 OF 67
APPROVED	#	TITLE	SCALE
DE APPR.	#	212S DETAIL PARTS	1:2
DATE	08.03.14	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D210-725-1-A7

X	First Article	X	Prototype
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Measured by:	HR
Date:	10-10-87

Audited by:	
Date:	10/10/28

Prototype Approval:	N/A
Date:	N/A

H:\FORMS\Quality Assurance\approved QA\FAI revD